



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7301
Job Sheet 186049



Part No: 647.7301

Job Qty: 1 ea

Part Name: EC135 Cable Cutters System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.7300 REV.D IPP REV:A 12.10.05 NEW ISSUE DD VERF:JLM IPP REV:B 16.04.26 sa per dwg revB DD
VERF:JLM IPP REV:C 16.11.15 dwg rev.c DD VERF:JLM IPP REV:D 17.12.07 AS PER DWG REV.D DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/13/18	12/13/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 13 2018
110	Packaging	1 pcs	12/13/18	12/13/18	0.00	0.00	Packaging1-1	DAS 46	DAS 69
120	QC	1 pcs	12/13/18	12/13/18	0.00	0.00	QC4	46	9-89
125	DC	1 pcs	12/13/18	12/13/18	0.00	0.00	DC	9-89DAS	9-89
130	Packaging	1 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-1	46	DAS 21
140	QC21-FG	1 Ea	12/13/18	12/13/18	0.00	0.00	QC21	9-89	DAS 21

Part Op 125 - Photocopy bluefile & type labels per PPP 647.7301
Descriptions: 130 - Identify and pack for shipping as per PPP 647.7301 Location : FG109

DEC 12 2018
DEC 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2600-LW	Washer, Camlock Retaining	2 Ea (2 ea)	90-Start up Operation	5065265
26R16-1	Camloc Receptacle	2 Ea (2 ea)	90-Start up Operation	5041065
26S8-11	Camloc Stud	2 Ea (2 ea)	90-Start up Operation	5057449
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5124187
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5124187
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	50449525
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5032768
601.2375	Washer 90965A160	3 Ea (3 ea)	90-Start up Operation	5084898
601.2999	Screw	3 pcs (3 ea)	90-Start up Operation	5084899
601.3011	P-Seal	1.4000 ft (1.4 ea)	90-Start up Operation	5006166
647.0112	Strut Bracket	4 Ea (4 ea)	90-Start up Operation	5023582
647.1601	Wiper Deflector Aft	1 Ea (1 ea)	90-Start up Operation	5122734
647.1602	Doubler Assembly	1 Ea (1 ea)	90-Start up Operation	FM130388-21
647.1610	Wiper Deflector Fwd	1 Ea (1 ea)	90-Start up Operation	5049879
647.1701	Skid Deflector Assembly	2 Ea (2 ea)	90-Start up Operation	5135225
647.1810	Nose Door Doubler	1 Ea (1 ea)	90-Start up Operation	FM130388
647.1811	Spacer	2 Ea (2 ea)	90-Start up Operation	FM130388-23
647.1812	Shim	13 Ea (13 ea)	90-Start up Operation	5084909
647.1814	Gusset LH	1 Ea (1 ea)	90-Start up Operation	5012454
647.1815	Gusset RH	1 Ea (1 ea)	90-Start up Operation	FM130388-20
647.1818	Nose Door Spacer	1 Ea (1 ea)	90-Start up Operation	FM130388-17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐											
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Date : _____		Step #: _____		MRB (QS1042) Approval																							
Container No: S127307 Part: 647.7301 Job No: 186049 Serial No/Batch: S127307 Revision: D Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02307LA 16/14/29, 16/STC LOA RI				Completed By																							
				Lead hand / Supervisor Approval Verification																							
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647.1913	Tee	1 Ea (1 ea)	90-Start up Operation	5100035
647.1914	Bracket	1 Ea (1 ea)	90-Start up Operation	5070833
647.1915	Support Angle	1 Ea (1 ea)	90-Start up Operation	5100443
647.2510	Sleeve	4 Ea (4 ea)	90-Start up Operation	5100035 5125082-55
647.2511	Nut	4 Ea (4 ea)	90-Start up Operation	FM130388-19
647.3201	Grounding Cable Assembly	1 Ea (1 ea)	90-Start up Operation	5022877
647.7401	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
647.7501	Lower Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5127356
647.7701	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5127768
647.7702	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118876
647.7818	Mounting Channel	1 Ea (1 ea)	90-Start up Operation	5084919
647.7819	Cross Bracket Fwd	1 Ea (1 ea)	90-Start up Operation	5084920
647.7820	Cross Bracket Aft	1 Ea (1 ea)	90-Start up Operation	
647.7821	Eye Bolt Fitting LH	1 Ea (1 ea)	90-Start up Operation	5084922
647.7822	Eye Bolt Fitting RH	1 Ea (1 ea)	90-Start up Operation	5084923
647.7910	Angle Bracket	2 Ea (2 ea)	90-Start up Operation	5084924
647.7911	Bracket	2 Ea (2 ea)	90-Start up Operation	5084925
647.7912	Clip	4 Ea (4 ea)	90-Start up Operation	5084926
647.7913	Doubler	2 Ea (2 ea)	90-Start up Operation	5084927
647.7914	Bracket	1 Ea (1 ea)	90-Start up Operation	F165270
647.7915	Bracket	1 Ea (1 ea)	90-Start up Operation	5026904
647.7916	Bracket	2 Ea (2 ea)	90-Start up Operation	5084930
647.7917	Bracket	1 Ea (1 ea)	90-Start up Operation	F131356
647.7918	Bracket	1 Ea (1 ea)	90-Start up Operation	F158067 F119030
647.7919	Shim	1 Ea (1 ea)	90-Start up Operation	5084920 5084933
647.8510	Insert	18 Ea (18 ea)	90-Start up Operation	5083890
647.8511	Insert	4 Ea (4 ea)	90-Start up Operation	5083571
647.8512	Insert	4 Ea (4 ea)	90-Start up Operation	5026305
AN3-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	5098034
AN3-4A	Bolt	2 Ea (2 ea)	90-Start up Operation	5060063
AN316C4R	Nut, Jam	4 Ea (4 ea)	90-Start up Operation	5080637
AN44-12A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5123453x1 5024839x1
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5065262
AN4C7A	Bolt	4 Ea (4 ea)	90-Start up Operation	5095478
AN4CH6A	Bolt	1 Ea (1 ea)	90-Start up Operation	FM126176
AN665-34R	Clevis	4 Ea (4 ea)	90-Start up Operation	5107789
CCR264SS-3-03	Cherry Rivet	24 Ea (24 ea)	90-Start up Operation	5082912
CCR274SS-3-03	Rivet	4 Ea (4 ea)	90-Start up Operation	F123785-0
CR3212-5-6	Cherry Rivet	2 Ea (2 ea)	90-Start up Operation	F124259
CR3213-4-2	Cherry Rivet	4 Ea (4 ea)	90-Start up Operation	5019424
CR3213-4-3	Rivet, Cherry	24 Ea (24 ea)	90-Start up Operation	5098033
CR3213-4-4	Rivet, Cherry	16 Ea (16 ea)	90-Start up Operation	50498075 5104374x16
CR3213-4-5	Rivet	8 Ea (8 ea)	90-Start up Operation	FM138414-40
CR3213-4-6	Rivet	17 Ea (17 ea)	90-Start up Operation	5019309
CR3213-5-3	Cherry Rivet	16 Ea (16 ea)	90-Start up Operation	5084873
CR3213-5-4	Cherry Rivet	12 Ea (12 ea)	90-Start up Operation	5084874
CR3522-4-3	Rivet	8 Ea (8 ea)	90-Start up Operation	5117367
CR3522-5-3	Rivet	8 Ea (8 ea)	90-Start up Operation	5080638
CR3523-4-3	Rivet	4 Ea (4 ea)	90-Start up Operation	5084876
CR3523-4-4	Rivet	24 Ea (24 ea)	90-Start up Operation	5038755
CR3523-5-3	Rivet	8 Ea (8 ea)	90-Start up Operation	5049827
MS21042-08	Use Ms21042L08	7 Ea (7 ea)	90-Start up Operation	5100409
MS21042-3	Nut	34 Ea (34 ea)	90-Start up Operation	5108577
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5094597
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5093592
MS21047-3	Nut Plate	12 Ea (12 ea)	90-Start up Operation	5103943
MS21266-2N	Grommet	1 Ea (1 ea)	90-Start up Operation	F123900
MS24694-S54	Screw	6 Ea (6 ea)	90-Start up Operation	5080644x4 5118346x2
MS27039-08-07	Screw	1 Ea (1 ea)	90-Start up Operation	5044221
MS27039-08-13	Screw	4 Ea (4 ea)	90-Start up Operation	5016508
MS27039-08-16	Screw Pan HD	2 Ea (2 ea)	90-Start up Operation	FM130388
MS27039-1-07	Screw	3 Ea (3 ea)	90-Start up Operation	5079112x1 5111086x2
MS27039-1-09	Screw	12 Ea (12 ea)	90-Start up Operation	5017101

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OTHER :																																																																					

MS27039-1-10	Screw	6 Ea (6 ea)	90-Start up Operation	3071834
MS27039-1-12	Screw	2 Ea (2 ea)	90-Start up Operation	3084889
MS27039-1-14	Screw	4 Ea (4 ea)	90-Start up Operation	F120449-40
MS27039-1-15	Screw	1 Ea (1 ea)	90-Start up Operation	5112435
MS27039-1-16	Screw	4 Ea (4 ea)	90-Start up Operation	3049833
MS27039-1-17	Screw (601.1954)	2 Ea (2 ea)	90-Start up Operation	FM127831-4
NAS1149C0432R	Washer	8 Ea (8 ea)	90-Start up Operation	5103990
NAS1149F0332P	Washer *-1	86 Ea (86 ea)	90-Start up Operation	5109991
NAS1149F0463P	Washer	8 Ea (8 ea)	90-Start up Operation	3097088
NAS1149F0532P	Washer	4 Ea (4 ea)	90-Start up Operation	F18057-4
NAS1149FN832P	Washer	14 Ea (14 ea)	90-Start up Operation	5100408
NAS6603-12	Bolt	4 Ea (4 ea)	90-Start up Operation	5007044
NAS6603-16	Bolt	4 Ea (4 ea)	90-Start up Operation	FM133523
NAS6604-66	Bolt	4 Ea (4 ea)	90-Start up Operation	FM130388.042

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2600-LW	2	126	0
	26R16-1	2	52	0
	26S8-11	2	62	0
	600.0990	1	12	0
	600.0991	1	12	0
	600.1012	1	25	0
	601.2045	1	21	0
	601.2375	3	87	0
	601.2999	3	40	0
	601.3011	1	139	0
	647.0112	4	82	0
	647.1601	1	22	0
	647.1602	1	9	0
	647.1610	1	47	0
	647.1701	2	2	0
	647.1810	1	45	0
	647.1811	2	66	0
	647.1812	13	148	0
	647.1814	1	48	0
	647.1815	1	36	0
	647.1818	1	57	0
	647.1913	1	48	0
	647.1914	1	42	0
	647.1915	1	42	0
	647.2510	4	52	0
	647.2511	4	20	0
	647.3201	1	9	0
	647.7401	1	0	0
	647.7501	1	0	0
	647.7701	2	0	0
	647.7702	2	13	0
	647.7818	1	9	0
	647.7819	1	7	0
	647.7820	1	0	0
	647.7821	1	18	0
	647.7822	1	14	0
	647.7910	2	65	0
	647.7911	2	55	0
	647.7912	4	165	0
	647.7913	2	8	0
	647.7914	1	42	0
	647.7915	1	40	0
	647.7916	2	60	0
	647.7917	1	48	0
	647.7918	1	33	0
	647.7919	1	4	0
	647.8510	18	153	0
	647.8511	4	86	0
	647.8512	4	51	0
	AN3-11A	4	145	0
	AN3-4A	2	346	0
	AN316C4R	4	33	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

AN44-12A	2	2	0
AN44-5A	2	27	0
AN4C7A	4	139	0
AN4CH6A	1	13	0
AN665-34R	4	25	0
CCR264SS-3-03	24	554	0
CCR274SS-3-03	4	22	0
CR3212-5-6	2	91	0
CR3213-4-2	4	130	0
CR3213-4-3	24	264	0
CR3213-4-4	16	626	0
CR3213-4-5	8	178	0
CR3213-4-6	17	119	0
CR3213-5-3	16	246	0
CR3213-5-4	12	137	0
CR3522-4-3	8	200	0
CR3522-5-3	8	96	0
CR3523-4-3	4	15	0
CR3523-4-4	24	91	0
CR3523-5-3	8	71	0
MS21042-08	7	1	0
MS21042-3	34	241	0
MS21042L4	8	2,487	0
MS21042L5	4	475	0
MS21047-3	12	454	0
MS21266-2N	1	8	0
MS24694-S54	6	406	0
MS27039-08-07	1	260	0
MS27039-08-13	4	578	0
MS27039-08-16	2	63	0
MS27039-1-07	3	204	0
MS27039-1-09	12	78	0
MS27039-1-10	6	260	0
MS27039-1-12	2	246	0
MS27039-1-14	4	383	0
MS27039-1-15	1	369	0
MS27039-1-16	4	573	0
MS27039-1-17	2	63	0
NAS1149C0432R	8	1,858	0
NAS1149F0332P	86	1,871	0
NAS1149F0463P	8	840	0
NAS1149F0532P	4	1,131	0
NAS1149FN832P	14	2,481	0
NAS6603-12	4	63	0
NAS6603-16	4	8	0
NAS6604-66	4	14	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER :																							

647.7301 - ship today, sans 647.7401 & 647.7820

Linda Lacelle

Wed 2018-12-12 10:38 AM

To: Sonia Quinon <squinon@dartaero.com>;

Cc: Shipping <shipping@dartaero.com>; Jason Leroux <jleroux@dartaero.com>;

			NAS6603-16	4	16	0	Ea
			NAS6604-66	4	2	0	Ea
	12/13/18	110 - Packaging	647.1610	1	43	0	pcs
			647.1701	2	3	0	Ea
			647.7401	1	0	0	pcs
			647.7501	1	3	0	pcs
			647.7701	2	12	0	Ea
			647.7702	2	9	0	pcs
			647.7820	1	4	0	pcs

